

Work Order ID 57344

April 6, 2010 7:47:06 AM

Rush



Page 1

Item ID: D2332-041

Revision ID:

Item Name: Lid Prop Assembly 6.69" long

Start Date: 4/06/10

Start Qty: 10.00

Required Date: 4/08/10

Req'd Qty: 10.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2332

Rev C1

100



Small Fab

0.00

Memo

0.00

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

m-h 10/04/06
SAD 10-04-06

14X

110



Brake NC

Brake NC

0.00

Memo

0.00

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)

m-h 10/04/06

14X

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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RUSA



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Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



Small Fab

Small Fab

Memo

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

0.00

0.00

= 7 m, 10/04/07

11X

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

D2332-7 - 8104102 x 11

D2332-5 - 8104102 x 11

D2332-11 - 8104102 x 11

D2332-13 - 8104102 x 11

8104102 X11

0.00

0.00

Memo

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: M108160

Q 10-4-8

X11

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ASAP!!

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Reference:

Accept



Setup Start

Stop

Cust Item ID:
Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

(11) PD 10.04.04

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Subtotal

(11)

170



Small Fab

Small Fab

Memo

1- Tumble

2- Assemble as per dwg D2332

0.00

0.00

=> m. 10/04/12

10-4-12

(11)

(11x)

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Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

8/10/04/12

QC

Quality Control

Memo

0.00

(HL)

190

Identify as per dwg & Stock Location: 5/2

0.00

Packaging

Memo

0.00

Packaging

10/04/12 (11)

200

QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/04/12 MF
10-4-12

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NOTE: Date & initial all entries

Picklist Print

April 6, 2010 7:47:05 AM

Page 1

Work Order ID: 57344

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Date: 4/06/10

Required Date: 4/08/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-4A Bolt			No			170	Each	45.0000	10.0000			

AN960JD416L

Purchased

No

170

Each

483.0000

30.0000

~~10X~~ m-k 10/04/12

Washer

NA S1149D0416J

M114056

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST346

483

110153

483

100

f

16.5000

1.0526

~~30X~~ m-k 10/04/12

M304R.250

Purchased

No

304 SS Round bar .250

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

MAT028

16.5

107387

16.5

SAD 10-09-06

10526

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

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Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Comments: IPP: B002.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Date: 4/06/10

Required Date: 4/08/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			110	f	29.6240	13.1579			
304 RD Tube .500 x .035W												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT017	29.624	
112187	4.75	
112800 ✓	24.874	

100	f	45.7400	4.5263
-----	---	---------	--------

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT018	45.74	
108756	12.08	
111457	33.66	

M304TR1.000W.049

Purchased



304 RD Tube 1.00 x .049W

m-h
10/04/06

13.1579

SAD 10-04-07

4.5263

April 6, 2010 7:47:05 AM

Shop Packet Print

Page 2

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IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Date: 4/06/10

Required Date: 4/08/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			170	Each	1,641.000	10.0000			
Nut												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST139	2	
111827	2	
Main Warehouse		
ST300	1639	
113422 ✓	631	
114108	1000	
9063	8	

10x m-h 10/04/12

April 6, 2010 7:47:05 AM

Shop Packet Print

Page 3

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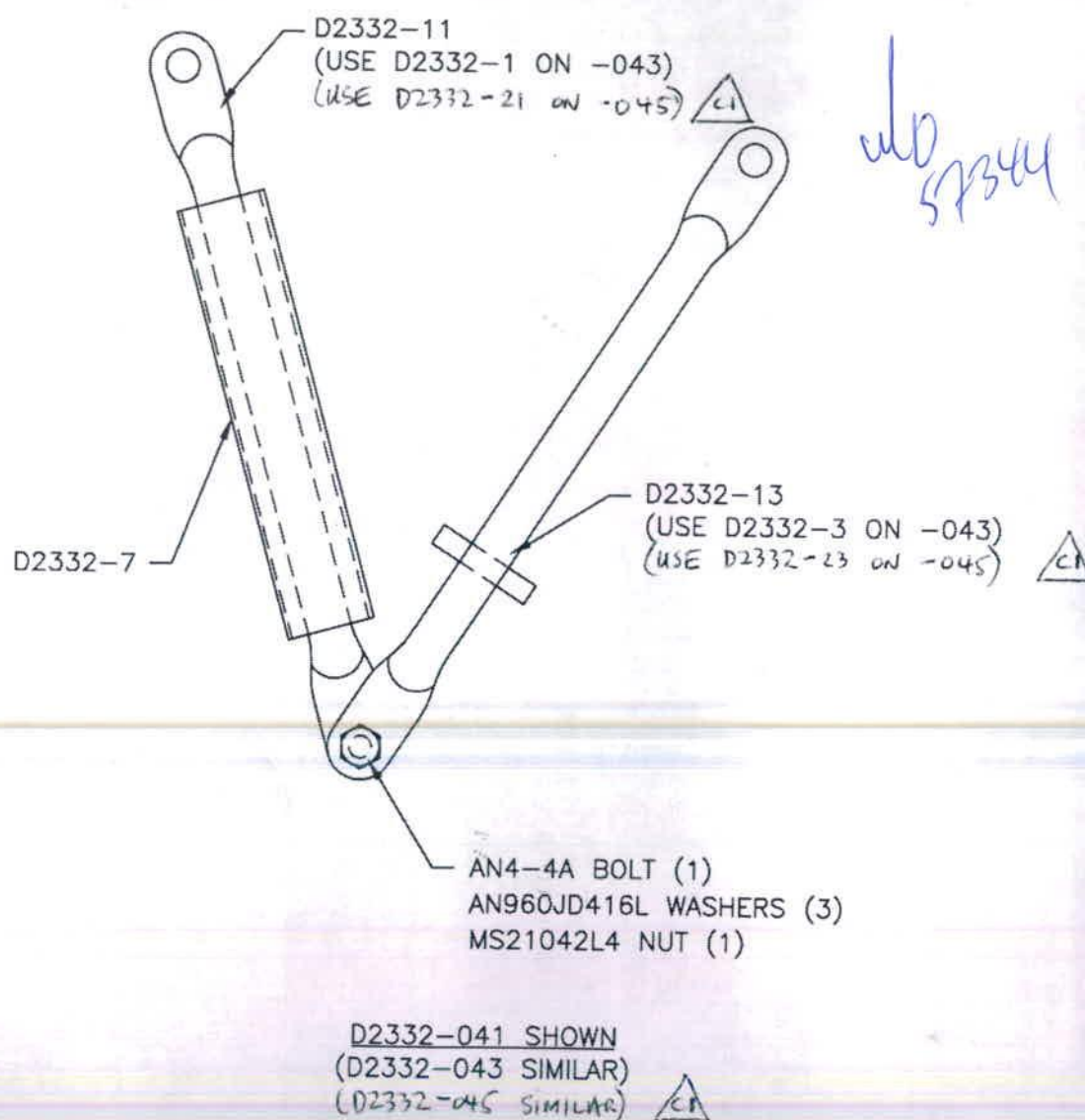
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NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03	TITLE LOD PROP ASSEMBLY		SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



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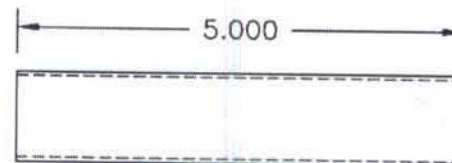
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DART



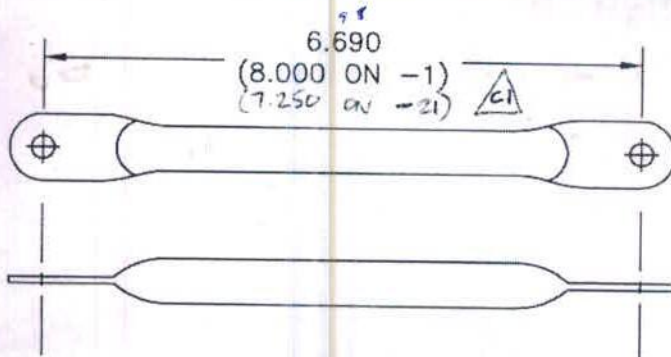
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 03.07.03	DRAWING NO. D2332	REV. C
	TITLE LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE 1:2
C	03.07.03	MAKE -041 PROP 6.61" LONG (57)
C1	03.08.06	MAKE -043 PROP 8.00" LONG (47)
		ADD -045 PROP 7.25" LONG (47)



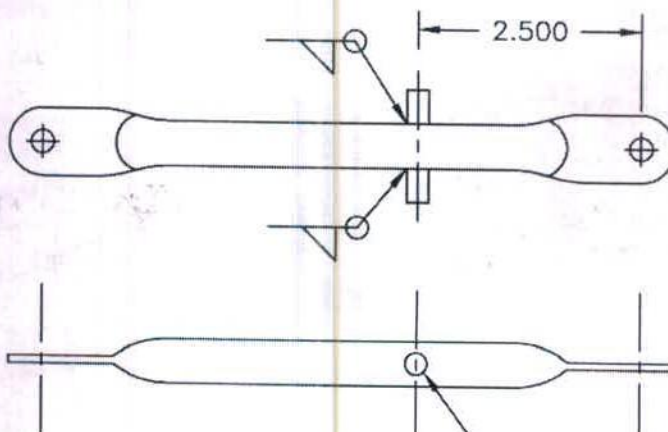
D2332-7 LOCKING COLLAR



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

DRILL 1/4 HOLE FOR D2332-5

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
D30104

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